

Date: Monday, 7/9/2007 11:38:38 AM
 User: Kim Johnston

Process Sheet

D

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	33317			
Estimate Number	12925			
P.O. Number	N/A		Part Number	D29331UP
This Issue	7/9/2007	S.O. No. N/A	Drawing Number	D2933 REV C
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type MACHINED PARTS	Drawing Revision	C
Previous Run	N/A		Material	N/A
Written By			Due Date	7/27/2007
Checked & Approved By		HJ 07.07.09	Qty:	8
Comment	Est Rev:A	New Issue 07-07-04 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B 31386
		J.F. 07/07/28
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
		J.F. 07/07/30 ⑧
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
		J.F. 07/07/30 ⑧
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET
		J.F. 07/07/30 ⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58_SADDLE, INBOARD, LEFT SIDE

Job Number: 33317

Part Number: D29331UP

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.07.30

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AS

07-07-31

⑥

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

N/A Stocked Un Painted.

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

17/07/02 (8)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17/08/03 (8)

Job Completion



Jan 07.08.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	33317
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		1.23"	1.20"	1.20"	1.21"		
B	0.100	0.140		1.21"	1.20"	1.18"	1.20"		
C	0.100	0.140		1.14"	1.20"	1.20"	1.21"		
D	0.210	0.230		1.221"	1.221"	1.220"	1.219"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		512"	512"	512"	512"		
I	1.572	1.582		1.578"	1.578"	1.578"	1.578"		
J	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
K	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
L	0.312	0.317		0.314"	0.314"	0.314"	0.314"		
M	0.235	0.240		0.235"	0.239"	0.239"	0.239"		
N	0.100	0.140		1.14"	1.21"	1.19"	1.18"		
O	0.540	0.560		0.550"	0.551"	0.550"	0.551"		
P	0.490	0.510		0.503"	0.503"	0.502"	0.502"		
Q	3.715	3.725		3.721"	3.721"	3.721"	3.721"		
R	2.470	2.510		2.496"	2.496"	2.496"	2.496"		
S	0.240	0.270		0.249"	0.248"	0.246"	0.250"		
T	0.100	0.180		1.30"	1.30"	1.30"	1.30"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.135"	1.137"	1.138"	1.132"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.	Audited by:	S.A.
Date:	07/07/129	Date:	02.07.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

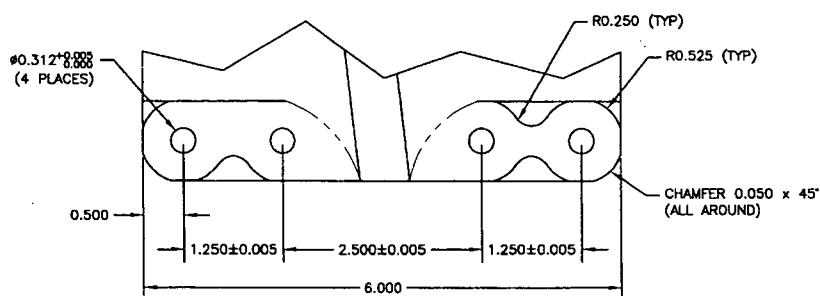
DART AEROSPACE LTD			Work Order:	33317
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		1.20"	1.22"	1.21"	1.21"		
B	0.100	0.140		1.21"	1.21"	1.20"	1.20"		
C	0.100	0.140		1.22"	1.13"	1.16"	1.17"		
D	0.210	0.230		1.29"	2.19"	2.19"	2.20"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
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O	0.540	0.560		0.550"	0.550"	0.550"	0.550"		
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Z	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.	Audited by:	S.A.
Date:	07/07/29	Date:	07.01.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	SPW

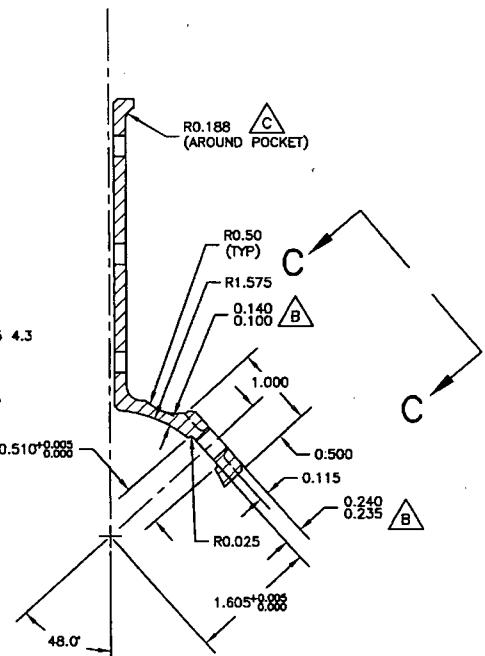


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

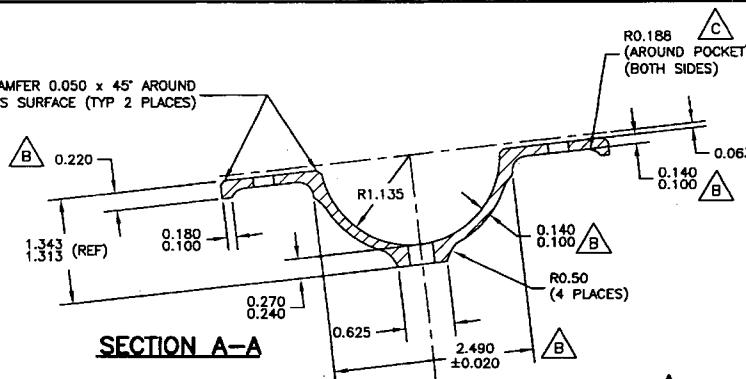
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

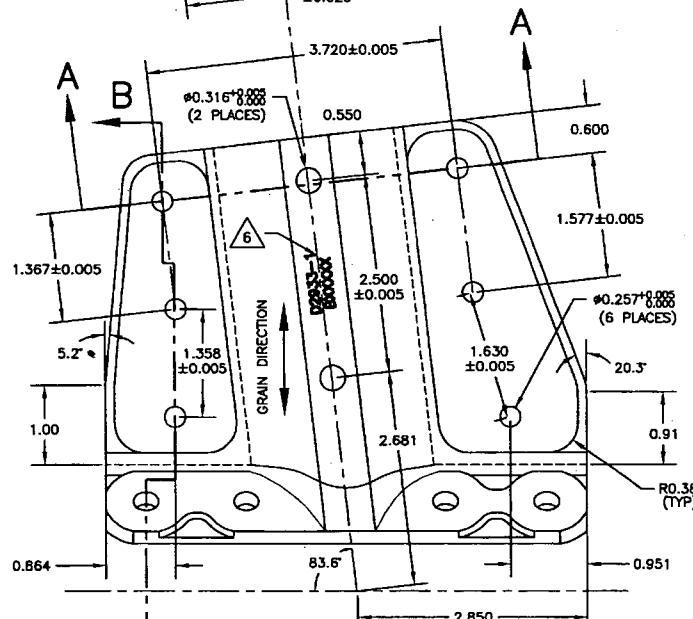


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



B

A

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 33317
 07.02.12

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 DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. C D2933
DATE		SHEET 1 OF 1 TITLE: SADDLE INSIDE SCALE: 23
06.11.09		